

Date: Tuesday, 7/1/2008 2:33:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 40185	
Estimate Number : 13061	
P.O. Number :	Part Number : D32459
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D3245 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35669	Material :
Written By :	Due Date : 7/18/2008 Qty: 10 Um: Each
Checked & Approved By : <u>08.07.01</u>	
Comment : Est B 04.12.06 Made in-house KJ/JLM	
Est Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3245	Gasket
-----	-------	--------



Comment: Qty.: 0.0426 sf(s)/Unit Total : 0.4263 sf(s)

GASKET

Batch: 31158

IB 8-7-2

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3245

Dwg Rev: B

IB 8-7-2

Prog Rev: B

(12)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-7-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/07/08 02 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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(12x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 79

8/7/2

SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 40185

Part Number: D32459

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40185
Description: Gasket		Part Number:	D3245-9
Inspection Dwg: D3245 Rev: B			Page 1 of 1

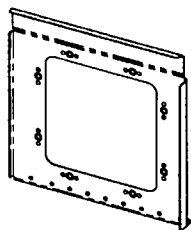
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

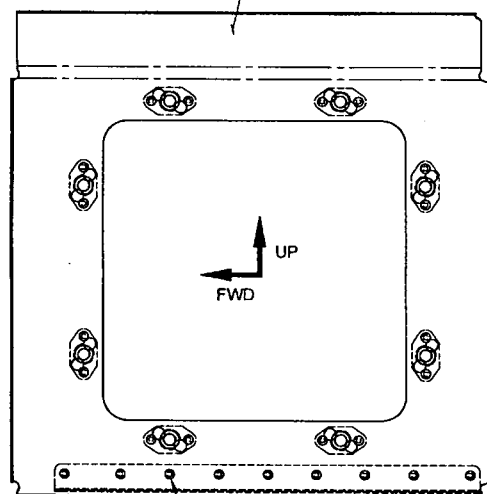
Measured by: PB		Audited by: S		Prototype Approval: N/A	
Date: 8-7-2		Date: 08/07/12		Date: N/A	

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD. JA	JA

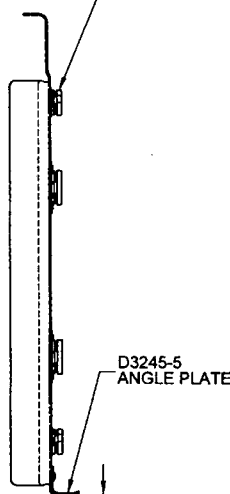


D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



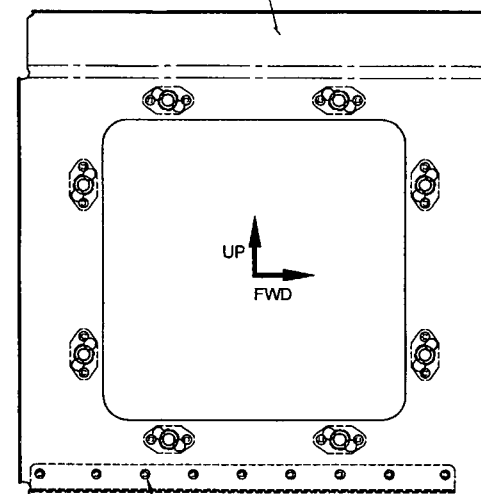
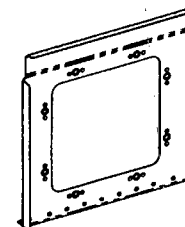
MS20615M3-3 RIVET
(9 PLACES)



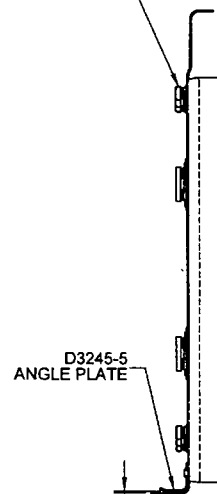
0.032
GAP

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)



0.032
GAP

D3245-041 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

D3245-042 ACCESS PANEL ASSEMBLY

RELEASED
107-10-23

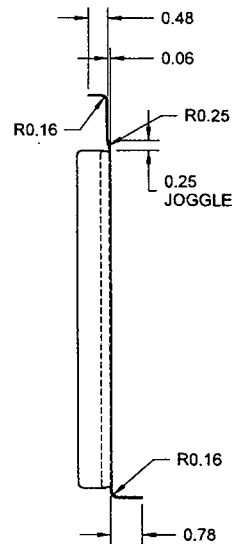
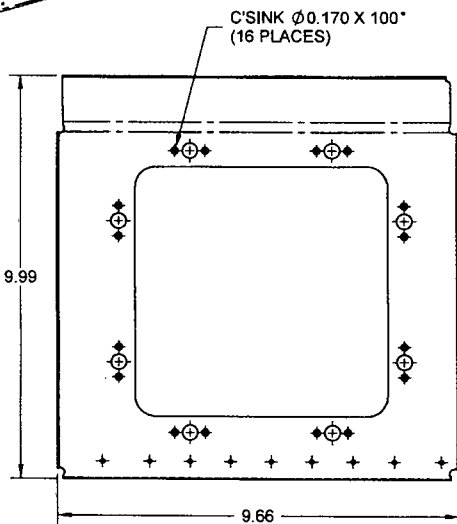
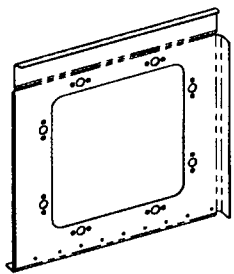
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

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WORK ORDER
NO 110185

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21080-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	PH	D3245	SHEET 1 OF 7
MFG. APPR.	DS	TITLE	SCALE
APPROVED	TH	ACCESS PANEL ASSEMBLY	1:2.5
DE APPR.	TH	DATE 07.10.02	

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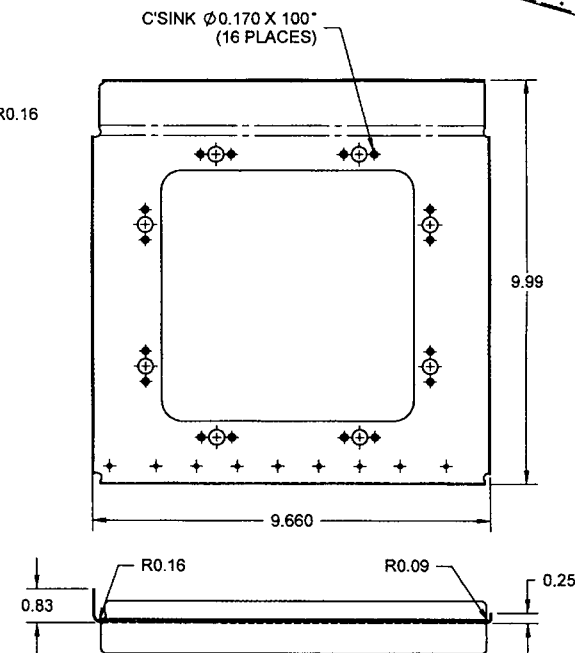
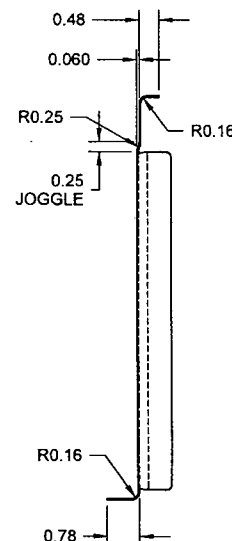
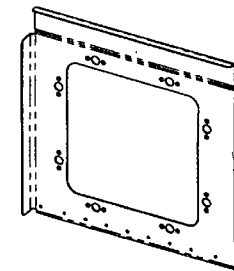


D3245-1 PANEL BEND DETAIL, LH

RELEASED
07-10-23

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

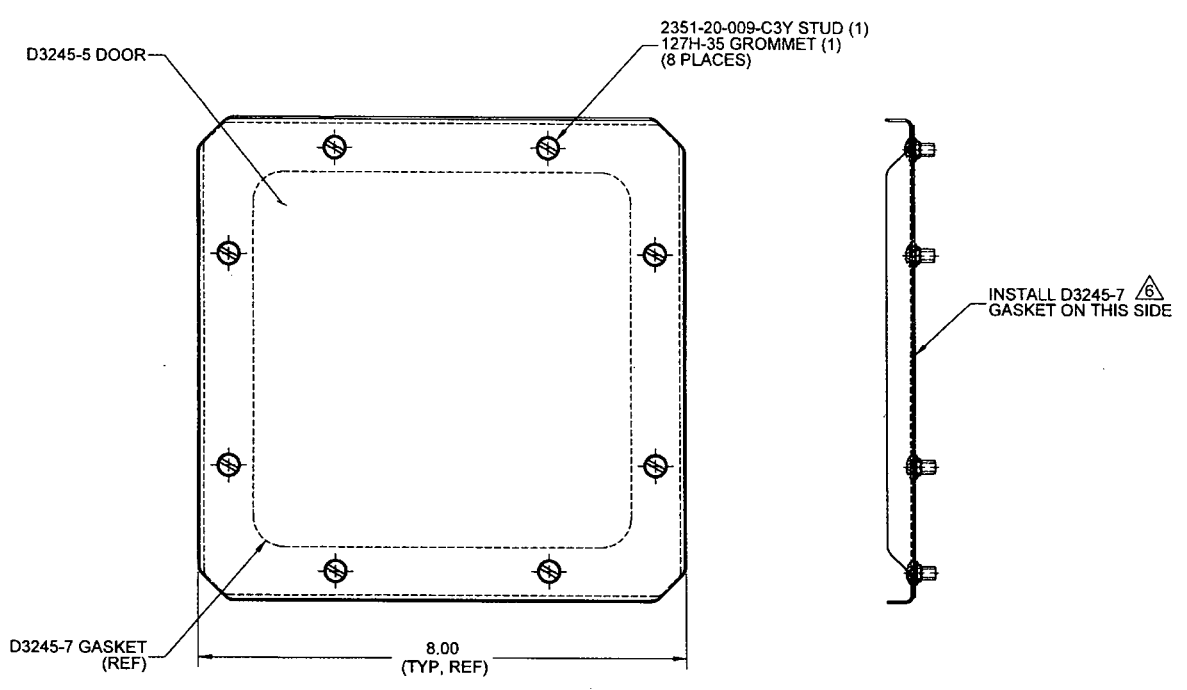
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WORK ORDER
10185



D3245-2 PANEL BEND DETAIL, RH

DESIGN	TH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 2 OF 7
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ACCESS PANEL ASSEMBLY	
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D3245-043 DOOR ASSEMBLY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

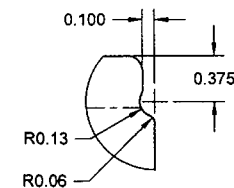
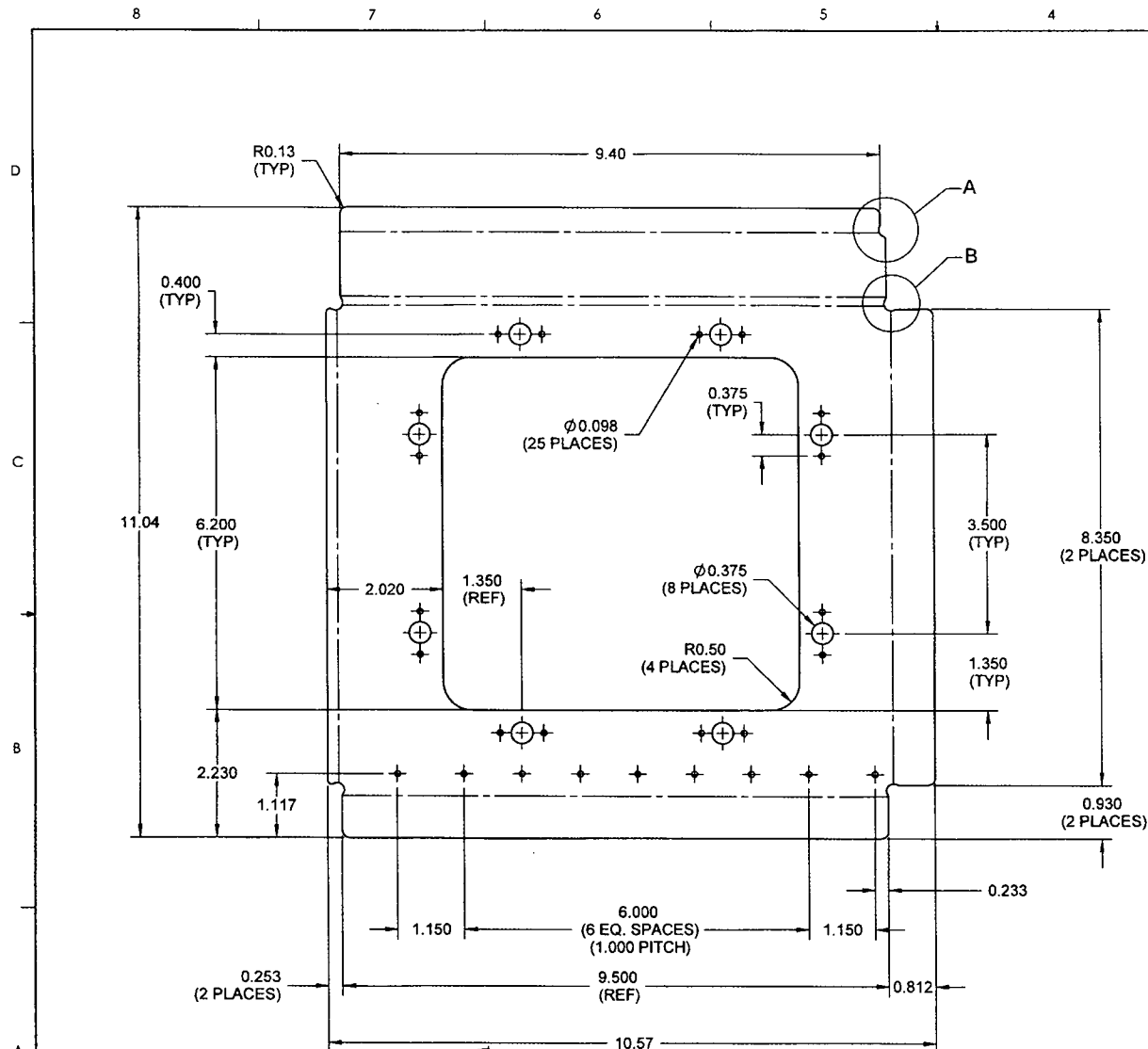
NO. 12085
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(1/17/07 10:33)

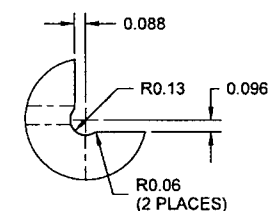
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
 - 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 9) WEIGHT: 0.73 lbs

DESIGN		DART AEROSPACE LTD
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245
MFG. APPR.	SS	REV. B
APPROVED	MD	SHEET 3 OF 7
DE APPR.	CH	TITLE ACCESS PANEL ASSEMBLY
DATE	07.10.02	SCALE 1:2
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8 7 6 5 4 3 2 1



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP. 4 PLACES)
SCALE 1:1

NOTES:

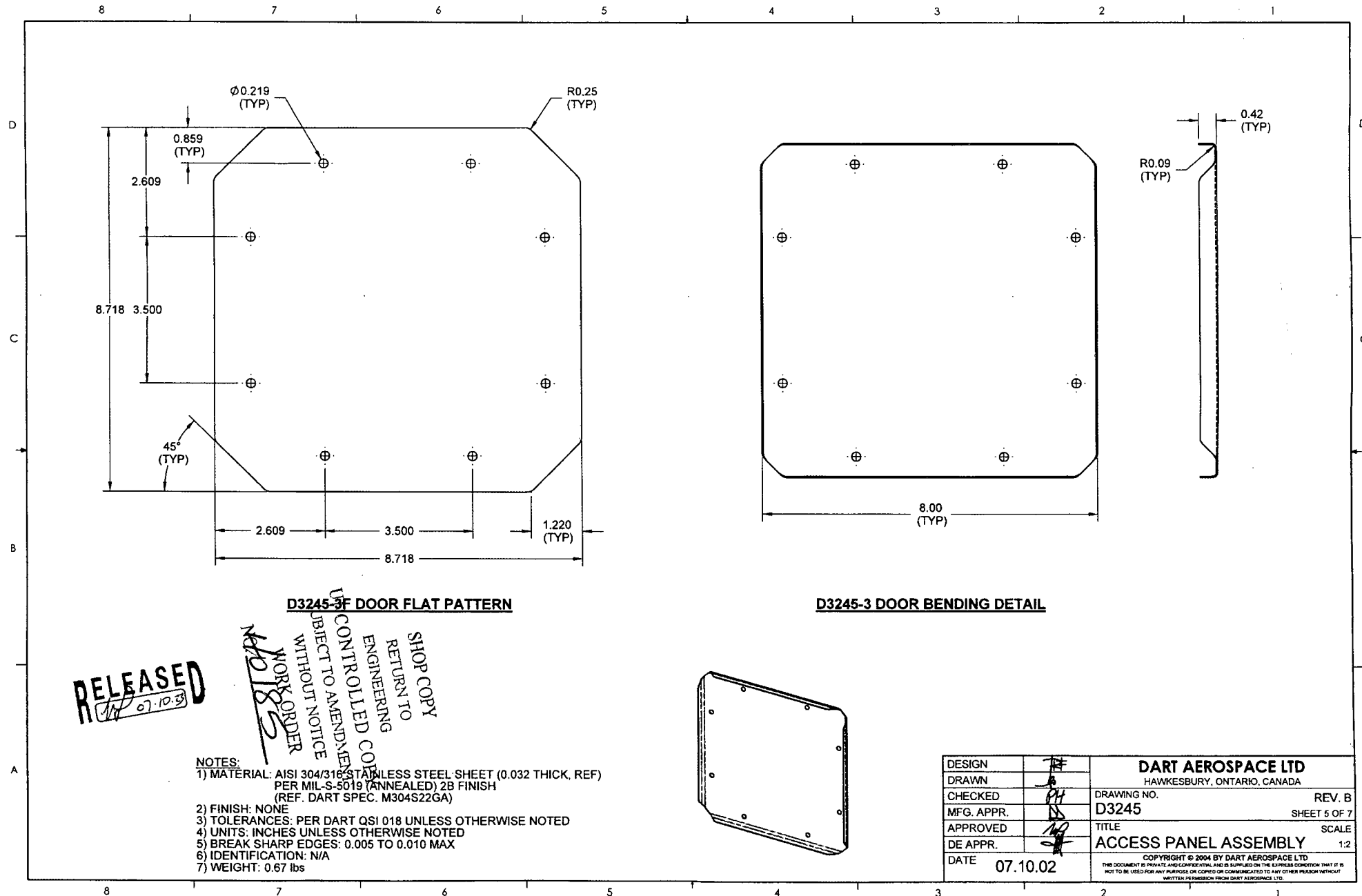
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

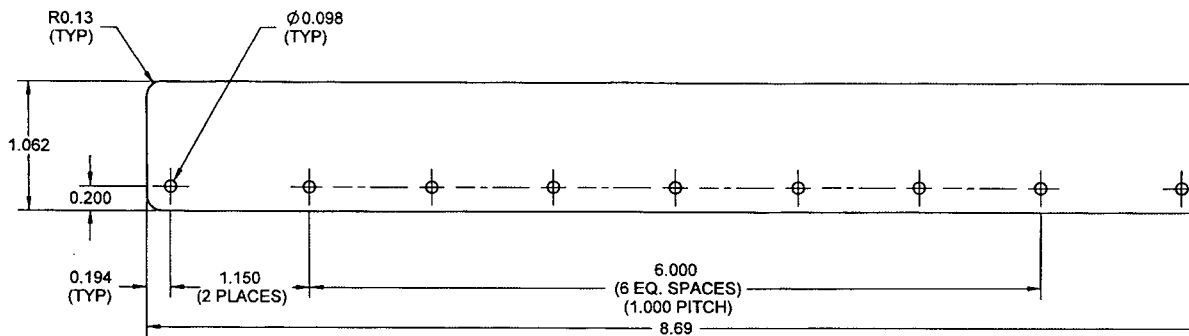
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DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO. D3245	REV. B
MFG. APPR.	1		SHEET 4 OF 7
APPROVED	1	TITLE	SCALE
DE APPR.	1	ACCESS PANEL ASSEMBLY	1:2
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17-010-23

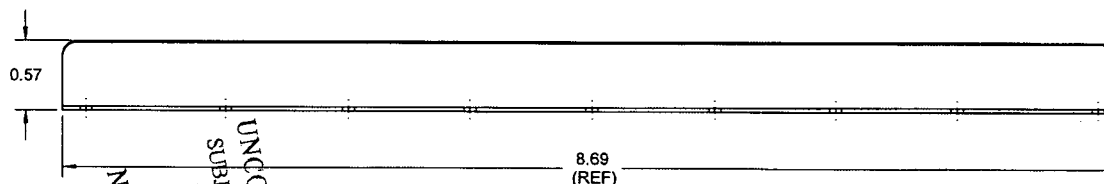
D3245-1F PANEL FLAT PATTERN

NO. 140185
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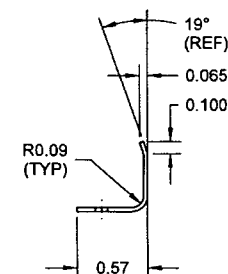




D3245-5F FLAT PATTERN



D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)



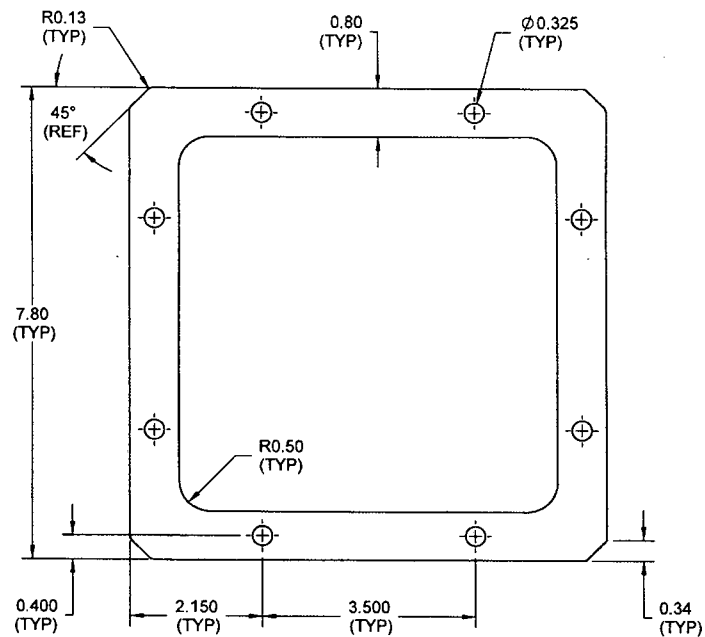
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

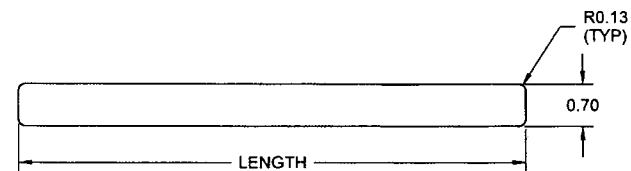
DESIGN	D3245	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 6 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:1
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07.10.23

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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
07.10.02

NO. 10185
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NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	7	DART AEROSPACE LTD
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245
MFG. APPR.	PH	REV. B
APPROVED	PH	SHEET 7 OF 7
DE APPR.	PH	TITLE ACCESS PANEL ASSEMBLY
DATE	07.10.02	SCALE 1:2

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